

Work Order ID 109605
November-26-13 12:53:47 PM

D2174-041
B109605

109605

Page 1

Item ID: D2174-041 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Web Assembly
Start Date: 11/21/13 Start Qty: 6.00 *6* Cust Item ID:
Required Date: 11/21/13 Req'd Qty: 6.00 *6* Customer:
Reference:

Approvals: Process Plan: MCS Date: 13-11-22 Tooling: Date: Run Start *NR1*
QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2174	Rev E								

100 0.00
100 Small Fab
Small Fab Memo 0.00
Small Fab 1- Assemble as per Dwg D2174-0412- Identify as D2174-041

110 0.00
110 QCS- Inspect part completeness to step on W/O
QC Memo 0.00

120 0.00
120 White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum
Powdercoat Memo 0.00
Powder Coating START TIME: 9:20 OVEN TEMPERATURE: 9:00
FINISH TIME: 9:00

DAS
36
9-89

DAS
34
9-89

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Setup Start *NS1*

Stop *NS2*

6

Start Date: 11/21/13 **Start Qty:** 6.00

Required Date: 11/21/13 **Req'd Qty:** 6.00

6

Customer:

Reference:

Run Start *NR1*

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

DAS
36
9-89

QC3- Inspect Part Finish

0.00

130

QC

Memo

. 0.00

Quality Control

140

0.00

140

Small Fab

Small Fab

Memo

0.00

Small Fab

Install nuts & bolts loosely as per Dwg D2274

150

QC5- Inspect part completeness to step on W/O

0.00

150

QC

Memo

0.00

Quality Control

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Item ID: D2174-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Web Assembly
 Start Date: 11/21/13 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 11/21/13 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location: ST240	0.00							
160									
Packaging	Memo	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control									

Lex. 13-11-28.

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[Signature] / Rm 13/12/02
 MF
 13-11-29

Picklist Print

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Work Order ID: 109605

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Parent Item: D2174-041

D2174-041

Parent Item Name: Web Assembly

Start Date: 11/21/13

Required Date: 11/21/13

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP: D04.06.10Reformat; Changed Step 2KJ/JLM
IPP Rev:E As per Rev E 06-11-22 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2174-1		Manufactured	No			100	Each	14.0000	1	6			DAS 36 9-89
D2174-1									**			13/11/26	
Web													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				GA				14					
					107943			14					
D2175-1		Manufactured	No			100	Each	6.0000	1	6			DAS 36 9-89
D2175-1									**			13/11/26	
Angle LH													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				GA				6					
					108088			6					
D2175-2		Manufactured	No			100	Each	15.0000	1	6			DAS 36 9-89
D2175-2									**			13/11/26	
Angle RH													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				GA				15					
					108110			15					

Picklist Print

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Work Order ID: 109605

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Parent Item: D2174-041

D2174-041

Parent Item Name: Web Assembly

Start Date: 11/21/13

Required Date: 11/21/13

Start Qty: 6.00

Required Qty: 6.00

MS21042L08

Purchased

No

100

Each

4,889.000

4

24

MS21042I 08

Nut

**

13/11/27
DAS
36
9-89

Location

Loc Qty

Loc Code

ST314

1631

122141

3

122452

9

122814

12

123900

107

m127410

1500

ST505

2000

125445

2000

ST509

1258

m127304

1258

24

AN526C832R14

Purchased

No

140

Each

379.0000

4

24

AN526C832R14

Screw

**

13/11/27
DAS
36
9-89

Location

Loc Qty

Loc Code

ST345

379

124215

379

24

MS20470AD4-6

Purchased

No

140

Each

2,132.000

19

114

MS20470AD4-6

RIVET

**

13/11/26
DAS
36
9-89

Location

Loc Qty

Loc Code

GA

3

118927

3

ST306

1971

m127305

1971

49

ST336

127

125654

127

65

ST505

31

123021

31

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Shop Packet Print

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Parent Item: D2174-041

D2174-041

Parent Item Name: Web Assembly

Start Date: 11/21/13

Required Date: 11/21/13

Start Qty: 6.00

Required Qty: 6.00

NAS1149DN832J

Purchased

No

140

Each

2,991.000

4

24

NAS1149DN832.I

**

13/11/27

DAS
36
9-89

Washer

Location

Loc Qty

Loc Code

ST293

423

123603

5

124555

398

M126221

20

ST510a

2568

M126319

1568

M127255

1000

24

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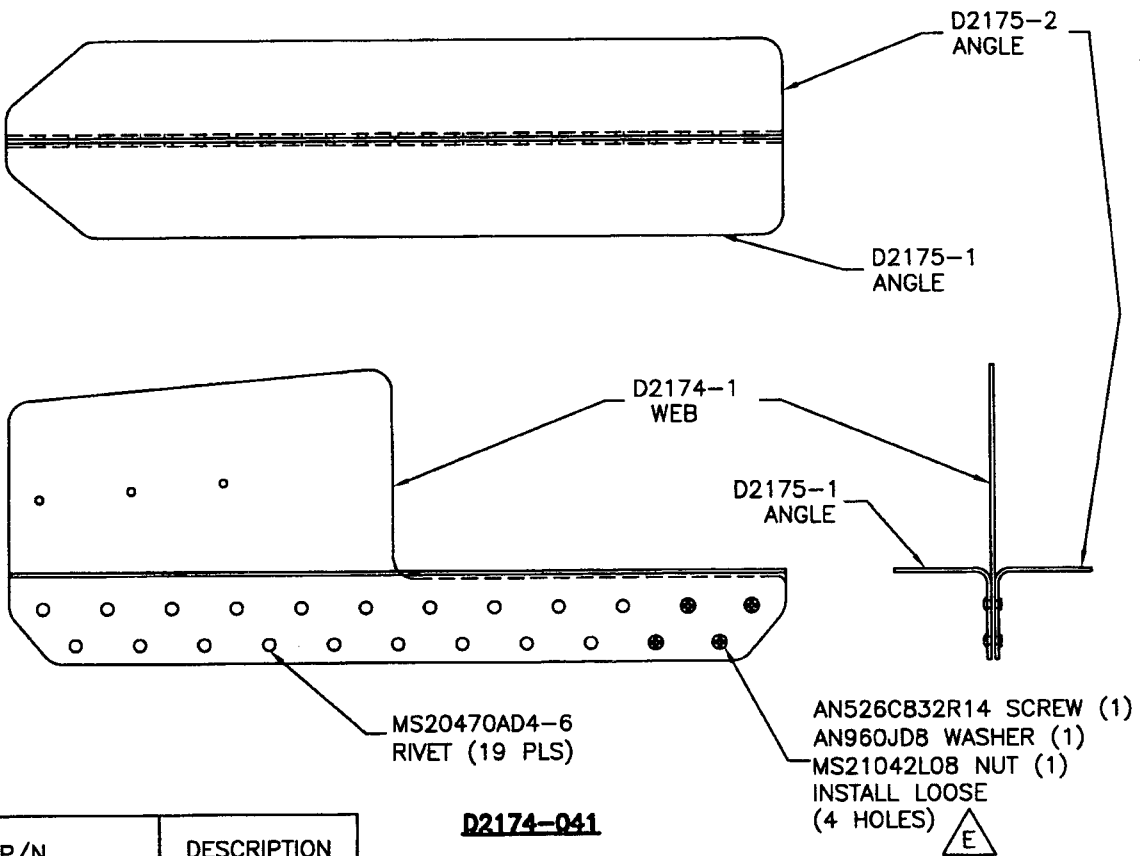
Shop Packet Print

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DART

109605
MCS
13-11-22

DESIGN	DRAWN BY	DART AEROSPACE LTD
RF	CE	HAWKESBURY, ONTARIO, CANADA
CHECKED PH	APPROVED CH	DRAWING NO. D2174
DATE 06.09.25	TITLE WEB ASSEMBLY	REV. E SHEET 1 OF 2 SCALE 1:3
A	95.10.25	NEW ISSUE
B	96.01.18	RE-DRAWN
C	00.09.11	UPDATE FINISH SPEC.
D	04.06.03	RE-DESIGN
E	06.09.25	INC 4 HOLES TO Ø0.172; CHG HARDWARE



D2174-041

QTY -041	P/N	DESCRIPTION
X	D2174-041	WEB ASSEMBLY
1	D2174-1	WEB
1	D2175-2	ANGLE
1	D2175-1	ANGLE
4	AN526C832R14	SCREW
4	AN960JD8	WASHER
4	MS21042L08	NUT
19	MS20470AD4-6	RIVET

NOTES:

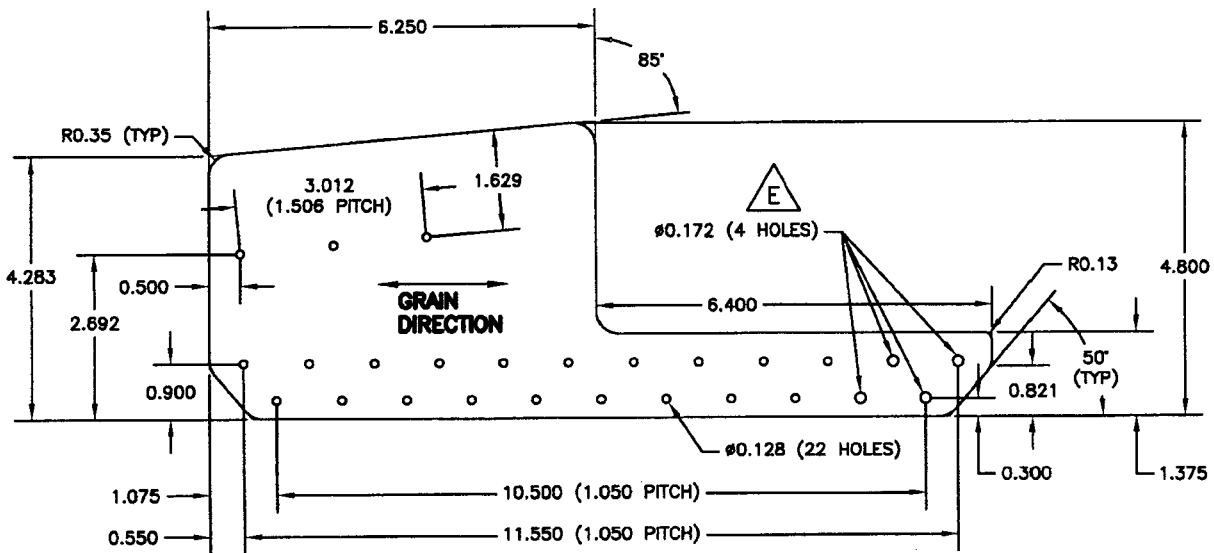
- 1) FINISH: POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) IDENTIFY WITH P/N D2174-041 USING FIND POINT PERMANENT INK MARKER.

RELEASED
06.10.13

DART

DESIGN	DRAWN BY		DART AEROSPACE LTD	
RF	CE		HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. E	
PH	PH	D2174	SHEET 2 OF 2	
DATE	TITLE		SCALE	
06.09.25	WEB		1:3	

RELEASED
JAN 16 1963



D2174-1

NOTES:

- 1) MATERIAL: 2024-T3 SHEET (QQ-A-200/4) 0.063 THICK (REF. DART SPEC. M2024T3S.063)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) BREAK ALL SHARP EDGES 0.005 TO 0.010
5) ALL DIMENSION ARE IN INCHES

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